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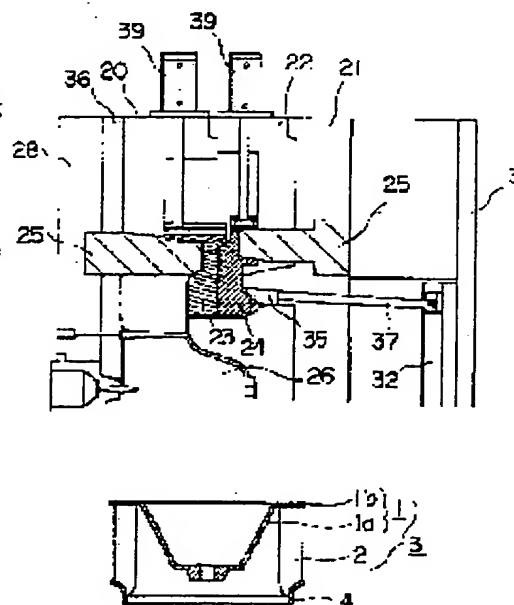
(21)Application number : 05-161948 (71)Applicant : TOSHIBA CHEM CORP
(22)Date of filing : 30.06.1993 (72)Inventor : YAMAGISHI SAKAE
TAKAHASHI TADASHI

(54) FAN MADE OF RESIN, METHOD FOR MONOLITHIC MOLDING THEREOF AND MOLDING DIE THEREFOR

(57)Abstract:

PURPOSE: To improve a weight balance and to reduce the cost by molding monolithically a fan having a construction wherein a fitting plate of a hat type and a ring-shaped air-straightening and reinforcing plate being opposite thereto are connected by a plurality of vanes juxtaposed radially.

CONSTITUTION: This fan has a construction wherein an upper-end flange 1b of a fitting plate 1 of a hat type and a ring-shaped air-straightening and reinforcing plate 4 are connected by a plurality of vanes 2 arranged in radial directions. As for a die for molding this monolithically, a cavity insert die 26 is fitted to a stationary template 20 and a core insert die being opposite thereto is fitted to a movable template 21. A notch 35 for molding the reinforcing plate 4 is embedded around the base end of the core insert die and made movable forward and backward. Outside of the core insert die, a plurality of vane insert dies (core-slides 24 and cavity slides 23) for molding discrete vanes 2 are provided. Locking blocks 25 are fixed to the movable template 21 and a stationary die plate 28 and the undercut parts thereof are made to engage with the vane insert dies 23 and 24. After molding, the vane insert dies 23 and 24 are drawn outward in such a manner that a time lag occurs in conformity with the movement of a movable die.



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